

Date: Wednesday, 2/20/2008 4:23:25 PM
 User: Kim Johnston

Process Sheet

| | |
|------------------------------------------------|-------------------------------------------|
| Customer : CU-DAR001 Dart Helicopters Services | Drawing Name : EXTRUSION "I" BEAM TUBE 4" |
| Job Number : 37544 | |
| Estimate Number : 10154 | |
| P.O. Number : | Part Number : D25001190 |
| This Issue : 2/20/2008 S.O. No. : | Drawing Number : D2500 REV G |
| Prsht Rev. : NC | Project Number : N/A |
| First Issue : / / Type : PURCHASED PARTS | Drawing Revision : G |
| Previous Run : 34729 | Material : |
| Written By : | Due Date : 3/17/2008 Qty: 80 Um: Each |
| Checked & Approved By : <u>2008 02 21</u> | |
| Comment : Est: G 02.09.05 Added DSK 066 KJ/RF | |
| est H 07.07.06 rev G dwg EC | |

Additional Product

Job Number:



| | | |
|---------|-----------------------|---------------|
| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|

1.0 PG

PURCHASING



Comment: PURCHASING

Issue P/O: 5770C208102/21

- a) Extrude as per Dwg D2500
- b) Material: 6061-T6 (QQ-A-200/8)
- c) Minimum yield tensile strength = 35 ksi
- d) Minimum ultimate tensile strength = 38 ksi
- e) ~~Minimum~~ elongation = 8%
- f) Order at 190" long
- g) Bon L Canada Inc. tool # 897105
- h) To be packed per DSK 066
- i) Pull test to ASTM standard B221 required.
- j) Material certification is required

80

2.0

D25001190P

Ext'n - "I" Beam Tube 4"



Comment: Qty.: 1.0000 Each(s)/Unit Total: 80.0000 Each(s)
 EXTRUSION "I" BEAM TUBE 4"

3.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage
 Ensure material certification is attached

C208102/21

4.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

Inspect dimensions per Dwg D2500
 Check Pull test per Dwg D2500 for compliance page attached.

2008 03 20
83
37
46
23

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|--------------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Wednesday, 2/20/2008 4:23:25 PM

User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: EXTRUSION 'I' BEAM TUBE 4"

Job Number: 37544

Part Number: D25001190

Job Number:



Seq. #:

Machine Or Operation:

Description :

Check hardness with Webster tester

5.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: Back Hall

BB 08/03/27 X23

6.0

QC21

FINAL INSPECTION/W/O RELEASE



(83)

Comment: FINAL INSPECTION/W/O RELEASE

208/03/27

Job Completion



MF

08-03-27

u

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries



| | | | |
|-------------------------------|--------------------------------|----------------------------------------------------------|------------------------|
| DESIGN <i>[Signature]</i> | DRAWN BY <i>[Signature]</i> | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED <i>[Signature]</i> | APPROVED <i>[Signature]</i> | DRAWING NO. D2500 | REV. G SHEET 1 OF 3 |
| DATE 07.04.17 | | TITLE EXTRUSION | SCALE NTS |
| A | 96.03.19 | NEW ISSUE | |
| B | 96.03.24 | CHANGE INTERNAL WEB | |
| C | 96.04.26 | ADD D2500-3 WEB | |
| D | 96.10.07 | ADD MATERIAL PROPERTIES | |
| E | 96.10.24 | CHANGE MATERIAL TEMPER | |
| F | 97.09.29 | CHANGE MAT. TO 6061-T6 | |
| G | 07.04.17 | ADD NOTES 3,5,6 | |

RELEASED
07-06-28 *[Signature]*

1. MATERIAL: 6061-T6 (QQ-A-200/8)

MINIMUM TENSILE YIELD STRENGTH = 35 KSI
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
MINIMUM ELONGATION = 8%

A SAMPLE FROM EACH BATCH WILL BE PULL TESTED TO
ASTM STANDARD B221 BY AN APPROVED TESTING FACILITY
TO ENSURE THAT THE BATCH MEETS THE ABOVE
MINIMUM MECHANICAL PROPERTIES

2. BREAK ALL SHARP CORNERS 0.010 MAX

3. ALL DIMENSIONS ARE IN INCHES

4. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE
NOTED.

5. FOR D2500-1 PART NUMBER IS D2500-1-XXX WHERE XXX IS
CUT LENGTH (EX. D2500-1-190 IS 190" LONG)
D2500-1 EXTRUSION MANUFACTURED FROM:

- A) BON L DIE # 897015 -> PREFERRED
- B) CARADON MIDEAST DIE # PAH-28030
- C) CARADON MTL DIE # MH-18868

6. FOR D2500-3, PART NUMBER IS D2500-3-XXX WHERE XXX IS
CUT LENGTH IN INCHES (EX. D2500-3-100 IS 100" LONG)
D2500-3 EXTRUSION MANUFACTURED FROM:

- A) CARADON INDALEX DIE # MS-18867

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NO. 37544

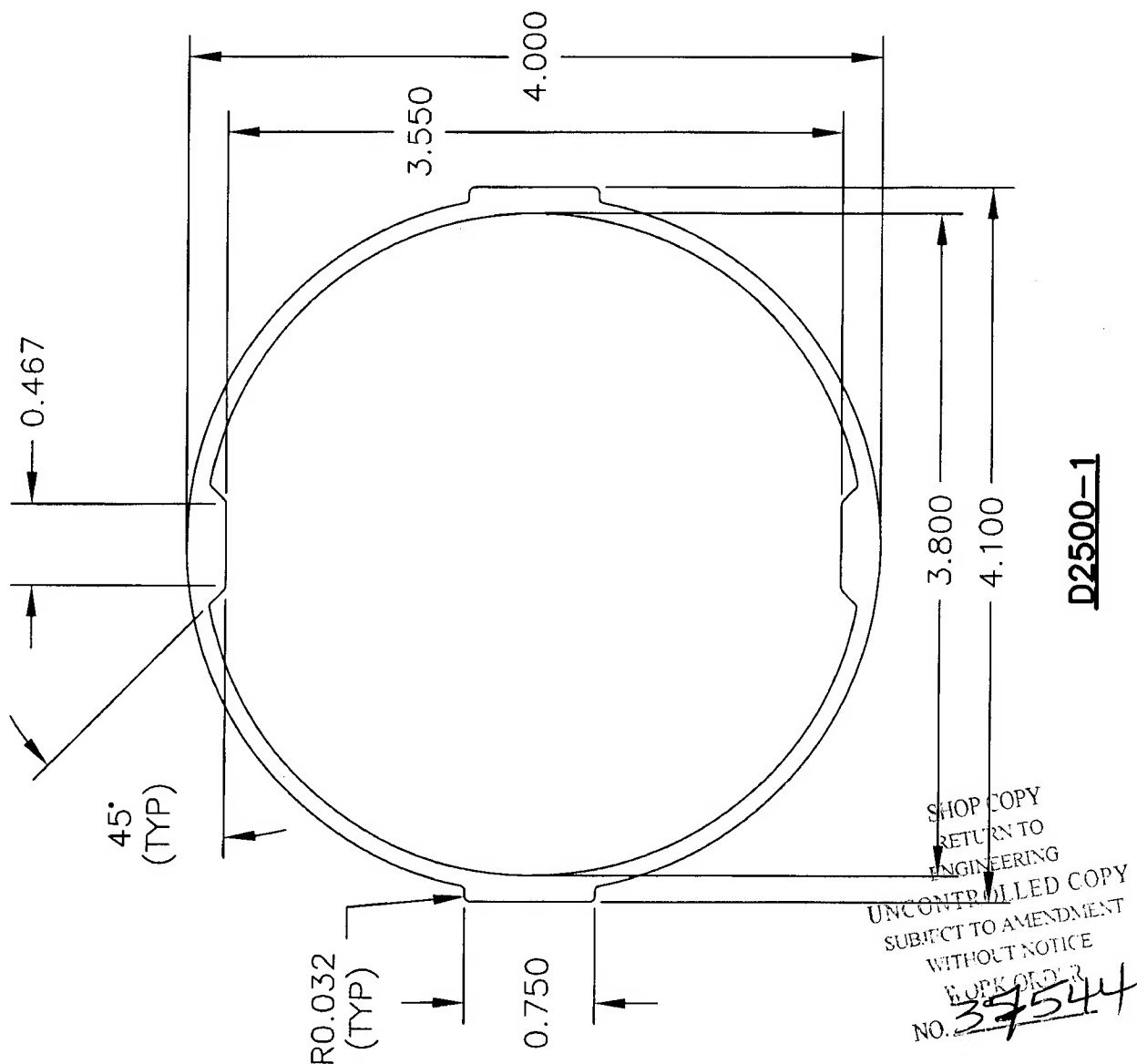
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| | | | |
|------------------|----------------|---------------------------------------------------|------------------------|
| DESIGN # | DRAWN BY RH | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED # | APPROVED # | DRAWING NO. D2500 | REV. G SHEET 2 OF 3 |
| DATE 07.04.17 | | TITLE EXTRUSION | SCALE 1:1 |

RELEASED
07.06.28 #



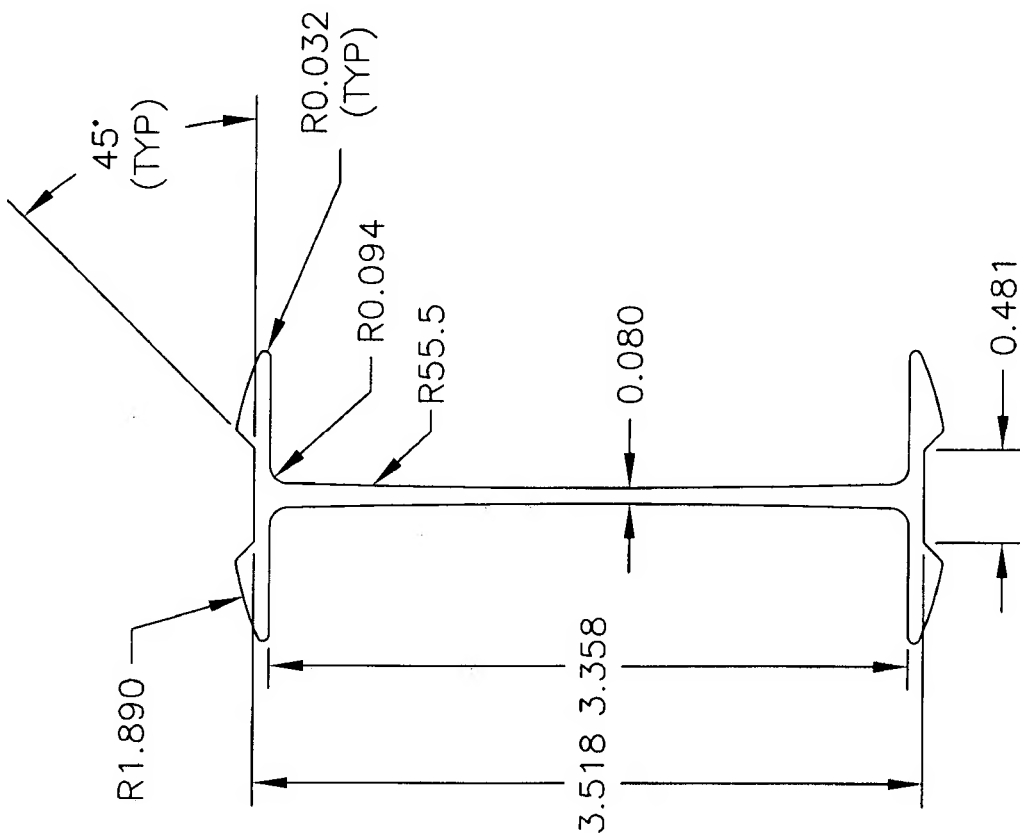
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| | | | |
|------------------|----------------|---------------------------------------------------|------------------------|
| DESIGN # | DRAWN BY PH | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED # | APPROVED # | DRAWING NO. D2500 | REV. G SHEET 3 OF 3 |
| DATE 07.04.17 | | TITLE EXTRUSION | SCALE 1:1 |

RELEASED
07.06.28 #



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INVOICING COMPANY AND LOCATION
SIGNATURE ALUMINUM CANADA
1850 CLEMENTS ROAD
PICKERING ON L1W 3R8

SHIPPING MANIFEST

ACCT# 00046024

| | |
|------------------------------------------------------------------------------------|------------------------------------------------------------------------------------------------|
| SHIP TO DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY ON K6A 1K7 CN | SOLD TO / PURCHASER DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY ON K6A 1K7 CN |
| PHONE 613-632-5200 | PHONE 613-632-5200 |

TERMS / FREIGHT
O / P

REFER TO
THESE NUMBERS ON
ALL CORRESPONDENCE

| |
|-----------------------------|
| MANIFEST DATE 03-16-08 |
| MANIFEST NUMBER 637736 |
| SALES ORDER NUMBER 25906 |

| | |
|---------------------------------------------|----------------------------------------------|
| CREDIT REP HAMBROOK, PAU 905-508-3250 | SALES REP |
| FIELD SALES REP Kutter A 450-435-6551 | CUST SERVICE REP Burton D 905-427-2227 |
| BILL OF LADING NUMBER 08375540 | |

| | | |
|----------------------|------------------------|----------------------------|
| CUSTOMER ID 46024 | ORDER DATE 02/25/08 | CUSTOMER PO NUMBER 5770 |
|----------------------|------------------------|----------------------------|

| | | |
|-----------------|-------------------------|-------------------|
| LOCATION PIC | TRAILER NUMBER 57375 | SALESMAN 59358 |
| JOB | | |

| 08375540 | | | | | | | | | | | |
|----------|-------------------------|------|---------------------------|----------------------|-------------------|-------------------------|---------------|--------------|--------------|------|--------------|
| ITEM NO. | ORIGINAL ORDER QUANTITY | UNIT | PREVIOUS SHIPPED QUANTITY | MFG. PART NUMBER | ALLOY & TEMPER | FINISH DESCRIPTIONN | THIS SHIPMENT | | | UNIT | QUANTITY DUE |
| | | | | CUSTOMER PART NUMBER | LENGTH | FABRICATION DESCRIPTION | NBR OF PKGS | GROSS POUNDS | NET QUANTITY | | |
| | | | | | CUTTING TOLERANCE | SHIPPING TOLERANCE | | | | | |
| 01 | 80 | KG | 0 | DAA-897105-2 | 6061 /T6 | MILL | 4 | 1086 | 1054 | KG | 0 |
| | | M | 0 | D2500-1-190 | 190" | CERTIFICATE OF COMP | | | 400.56 | M | 0 |
| | | PC | 0 | | +5/16 " | (+010-010,0088-0072) | | | 83 | PC | 0 |
| | | | | | -0 " | | | | | | |
| | | | | | | | | | | | |
| | | | | LOT/TKT DETAIL: | | 25906010 / 264981 | 1 | 301 | 293 | | 23 PC |
| | | | | | | 25906010 / 264982 | 1 | 301 | 293 | | 23 PC |
| | | | | | | 25906010 / 264983 | 1 | 301 | 293 | | 23 PC |
| | | | | | | 25906010 / 264984 | 1 | 183 | 175 | | 14 PC |
| | | | | | | | | | | | 83 |

Transportation/Traffic damages and/or shortage claims are to be noted on the delivery copy of sellers shipping manifests and signed and dated below by customers authorized representatives.
No return materials will be accepted for credit without permission. The articles and/or services covered by this shipping manifest were produced in accordance with the fair labor standards act of 1938 as amended. Order accepted subject to the terms and conditions stated on the reverse side.

PAGE 1

CERTIFICATE OF COMPLIANCE

SIGNATURE ALUMINUM CANADA

1850 CLEMENTS ROAD
PICKERING, ON L1W 3R8

| Cert Date | Cert No | Sales Order | Page |
|-----------|----------|-------------|---------|
| 03/16/08 | 174785 | 25906 | 1 |
| Part PO | B/L No | Lot | Date |
| 5770 | 08375540 | 25906010 | 3/16/08 |

| Sold To | Ship To |
|-----------------------------------------------------------------------------|-----------------------------------------------------------------------------|
| 46024 DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7 | 46024 DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7 |

| Item No | Part No | Item Description | Cust Part |
|--------------|--------------|-------------------|-------------|
| 1.000 | DAA-897105-2 | 190" Mill 6061 T6 | D2500-1-190 |
| Gross Weight | 1086 KGS | | |
| Net Qty | 1,054 KG | 83 PC | 401 M 4 PKG |

| Specification | Die Desc |
|-------------------------------|----------|
| AMS-QQ-A-200/8 & ASTM B221-06 | |

| Mechanical Tests: | | | | | | |
|-------------------|-------------------|-----------------|-------------|--------------|------------------|--|
| Test No. | Tensile MPA / KSI | Yield MPA / KSI | %Elongation | Conductivity | Bend/ Drift HREW | |
| 1 | 302.7 / 43.9 | 273.1 / 39.6 | 9.9 | .0 | 92 | |
| 2 | 303.6 / 44.1 | 271.5 / 39.4 | 9.6 | .0 | 92 | |

| Chemical Analysis: | | | | | | | |
|--------------------|-----|-----|-----|-----|-----|-----|-----|
| SI | FE | CU | MN | MG | CR | ZN | TI |
| .66 | .26 | .25 | .09 | .84 | .07 | .05 | .01 |
| .61 | .28 | .25 | .06 | .89 | .05 | .05 | .02 |

This will certify that the material described herein has been inspected and tested in accordance with Signature Aluminum Canada's standard sampling and testing procedures or in accordance with the requirements of any specification forming a part of the material description to the extent indicated herein. Data of chemical composition for the material and test results from samples representative of the material are set forth above hereof or in any attachments hereto. This information shows that the material meets the applicable requirements. Inspection and test records are maintained on file. This certificate shall be deemed apart of and subject to the terms and conditions of warranty set forth on the reverse side of our order acknowledgment form. No other warranties are applicable.

Conchita Ko, QA Manager Signature Aluminum Canada Inc

